

ABSTRACT OF THE DISCLOSURE

A charging roller for a contact charging assembly is provided including a conductive substrate, an elastic layer which covers the periphery of the 5 conductive substrate, and a seamless tube externally so fitted as to cover the periphery of the elastic layer. The seamless tube constitutes a surface layer of the charging roller, and the charging roller has a surface of 3.0  $\mu\text{m}$  or less in ten-point average 10 roughness ( $Rz$  jis 94) and 0.10 mm or less in roughness curve average length ( $RSm$ ).